Work Orde Tuesday, March					*980	145*							Page 1
Item ID: Revision ID:	D3875-1				Accept	*N900	<b>040</b>	100	)*	Setup	Start	*N:	S1*
Item Name: Start Date: Required Date: Reference:		Start Qty: 1.00 Req'd Qty: 1.00	U	·1* ·1*		Cust Item I Customer:	D:				Stop	*N:	S2*
Approvals:	Process Plan:	:	Date://3	03-5	Tooling: _ SPC (Y/N):		ate:			Run	Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center II		Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
Draw Nbr	Revisi	ion Nbr											
D3875	Rev A												
*100  *100* HandThermo Hand Finishing The	rmoforming	<b>Memo</b> 1-Cut Shee	et to required Bla	nk size	0.00				x2				(DAS 07 13/03/05
105 *105* HandThermo	τ	Dry Material			0.00				£x	<del>_</del>			DAS
Hand Finishing The	rmoforming	Memo Dry Sheet Temp: Time IN:_ Time OUT	as per QS1022 P 7:00 7:00										13/03/05

1

Yes / No NCR:

## WORK ORDER NON-CONFORMANCE / UPDATE

	DQA:	Date: _	
Q	A Closed:	Date:	
DEPA	ARTMENT/PR	OCESS	
		Vater Jet ng. Coor ackaging Supplier	Engineering Quality Other

<u> </u>		-							QA Ciosea.	Date.		
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	PROCESS		
Part No.					Rework Scrap Use-as-is	Th	Skid-tube  Machining ermoforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other	
NCR No.					Work Order Update		Large Fab	Composite		Supplier		
Root	5	<u> </u>	0.		ption of work order update	Initia		tion	Sign &	Manifia Aire	061	
Cause	Date	Step	Qty	(	or Non-conformance	Chief E	ng Desc	ription	Date	Verification	QC Inspector	
Doc/Data  Equip/Tooling												
Operator												
Material											į	
Setup												
Other												
Process -										-		
Supplier												
Training									;			
Unapproved												
					F.A.	AULT CA	TEGORY					
Landing G	Gear				General							
	Bending				Bend	Gra	in		Ovalized		Pressure/Forced	
	Centre No	ot Concer	ntric to (	o/s	BOM/Route	Hard	dware		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld	
	Crushed/0	Crimped.			Burrs	Inst	ructions Incomplete/	Unclear	Part Lost/M	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	Mai	intenance		Part Moved	<u> </u>	<del>-</del>	
	Heat Trea	it			Countersink	Misl	abeled		Positioned V	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short	Misi	read		Power Loss/Surge Other			
	Ripples in	Bend			Drill Holes	Offs	et		-			
	Torque W	aves in E	xtrusion	,	Drawing	Out	of Calibration					
	Turning S	equence			Finish	Out of Sequence						
	Wave/Tw	ist in Tub	e		Folio	Out	side Dimensions					

PTO.

											DQA:	Da	te:	
NCR: Y	es / No				WORK ORDER NON-C	100	NFORI	MANCE / U	PDATE		QA Closed:	Da <sup>-</sup>	to:	
			-		DISPOSITION				AGAINST	) E	PARTMENT		ie.	
Work Orde	er: <u>98</u>	045			DISPOSITION	_			AGAINST L	<i></i>	PARTIVILITI	rrocess .		
	10.				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		l	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root				Descri	ption of work order update	Π	Initial	<i>p</i>	Action		Sign &	,	$\Box$	
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	scription		Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	Bledio	_	<u> </u>		s consumed RéD.				FOR RED	٠,	<u> </u>	-		
					F	AUL	T CATE	GORY						
Landi	ng Gear				General		-	•	·		-			
	Bending				Bend	L	Grain				Ovalized		Ш	Pressure/Forced
	Centre No	t Conce	ntric to	o/s	BOM/Route		Hardwa	are			Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorre	ct	Ш	Weld
	Crushed/0	Crimped.			Burrs		Instruc	tions Incomplet	e/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance			Part Moved			
	Heat Trea	t			Countersink		Mislab	eled			Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

## Work Order ID 98045

\*98045\*

Page 3

Tuesday, March	h 05, 2013 8:	06:18 AM		90l	14:0							r age .
Item ID: Revision ID: Item Name:	D3875-1 Floor Protect	cor		Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup	Start Stop	*N:	S1*
Start Date: Required Date Reference:	3/5/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					IV.	
Approvals:	Process Pl	an:	Date:	Tooling:	D:	ate:	· 	R	lun	Start	*N	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
160		QC5- Inspect part compl	eteness to step on W/O	0.00								
*160* QC Quality Control		Memo		0.00								AND A 11 MARINESTALL, LINE
				:								
*170 *170*		Identify as per dwg & Ste	ock Location:	0.00								
Packaging Packaging		Memo		0.00								
180		QC21- Final Inspection -	· Work Order Release	0.00								
*180* QC Quality Control		Memo		0.00						M.	B3.("	<b>)</b>

Just Sxtures Abulhar

										•	D	QA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFOR	MANCE / UPI	DATE		·			
											QA Clo	sed:	Date	e:	
14/5 ml. Omd						DISPOSITION				AGAINST DE	PARTM	ENT,	/PROCESS		
Work Ord	er: -					Rework	1		Skid-tube	Crosstube	1		Water Jet		Engineering
Part I	N۵					Scrap		I	Machining Machining	Small Fab	-	Pro	d. Eng. Coor.	$\dashv$	Quality
raiti	<b>v</b> O.					Use-as-is		1	noforming	Finishing	Rec		re/Packaging	$\dashv$	Other
NCR I	No.					Work Order Update			Large Fab	Composite	''''	, 5.0.	Supplier	$\dashv$	
	•						J			' -	_				<b></b>
Root					Descri	ption of work order update		Initial	Act	ion	Sign	&			
Cause		Date.	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descr	ription	Dat	:e	Verification		QC Inspector
Doc/Data															
Equip/Tooling				]										1	
Operator	Ш					•	Ì					-			
Material															
Setup	Ш														
Other															
Process														ļ	
Supplier	Ш														
Training	Ш														
Unapproved							<u> </u>						]		
							AUI	LT CATE	GORY						
Landi		l .				General	_	1		_	٦		г	_	
	-	Bending				Bend	<u></u>	Grain			Ovalize		1	$\dashv$	Pressure/Forced
	-	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa			-1		tolerance	_	Temperature/Cure
	-	Cracks				Broken/Damaged		<del>-</del>   `	ion Incomplete	<u> </u> _	Part In		<b>}</b> -	_	Weld
	$\vdash$	Crushed/0	Crimped.			Burrs	_	4	tions Incomplete/l	Jnclear	Part Lo			\	Wrong Stock Pulled
	$\vdash$	Cuffs				Contamination		Mainte			Part M				
		Heat Trea	t			Countersink		Mislabe	eled		Positio	ned \	<b>V</b> rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

**Picklist Print** 

Tuesday, March 05, 2013 8:06:43 AM

Work Order ID: 98045

\*98045\*

Parent Item:

D3875-1

\*D3875-1\*

Parent Item Name: Floor Protector

Start Date: 3/5/2013

Required Date: 3/12/2013

Page 1

Start Oty: 1.00

Required Oty: 1.00

Comments:

IPP Rev. A 09.02.06 New Issue DL

Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	718.0389	9.84	9.84			
*N/II EYQ 1	18 003	10 00*							**				

\*MLFXS 118-90318-08\*

Lexan Sheet

Location therm

Loc Qty

718.0389406 718.038941

Loc Code

NCR:	Yes	/	No

DQA: Date:

NCR: Y	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:													
									QA Closed:	Date:				
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS				
					Rework	1	Skid-tube	Crosstube		Water Jet	Engineering			
Part N	0.				Scrap	1 1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
					Use-as-is	Ther	moforming	Finishing	l	re/Packaging	Other			
NCR N	0				Work Order Update	]	Large Fab	Composite		Supplier				
Root		T .	ГТ	Descri	ption of work order update	Initial	I Ad	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	1	cription	Date	Verification	QC Inspector			
oc/Data							,				•			
quip/Tooling														
perator														
Material								•						
etup														
Other														
rocess														
Supplier														
Training						ļ			1					
Inapproved									<u> </u>	<u> </u>				
					F	AULT CAT	GORY							
Landin	g Gear				General				٦	_	<b>-</b>			
	Bending				Bend	Grain			Ovalized	<u> </u>	Pressure/Forced			
	Centre N	ot Conce	ntric to C	)/S	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure			
	Cracks			<u> </u>	Broken/Damaged	_	tion Incomplete		Part Incorre	<u> </u>	Weld			
	Crushed/	Crimped			Burrs	<del></del>	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination	Maint	enance	<u> </u>	Part Moved					
Heat Treat					Countersink	Mislab	eled		Positioned \		_			
Inspection Strip in Tube					Cut Too Short	Misrea	ad		Power Loss,	/Surge	Other			
Ripples in Bend					Drill Holes	Offset								
Torque Waves in Extrusion					Drawing	Out of	Calibration							
Turning Sequence					Finish	Out of	Sequence			· · · · · · · · · · · · · · · · · · ·				
Wave/Twist in Tube					Folio	Outsic	le Dimensions							

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						_
DART AEROSPA	CE LTD			Wo	rk Order:	98045
Description: Floor Pr	rotector			Pa	rt Number:	D3875-1
					Transfer in the second	
Inspection Dwg: D38	375 <b>Rev</b> : A					Page 1 of 1
	x	RTICLE INSF First Article HERMOFORF		Prototy		·
		TERMIOI OIL		1	88-41	
Description			Accept	Reject	Method of Inspection	Comments
Inside Radii less than	17					
Shape Definition						
Texture Retention						
Material imperfections scratching	such as bumps,	cracks, voids,				
		·				
				l		
Measured by:					Date:	
		TRIMMING	SECTIO	N		
Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.050	Min					· · · · · · · · · · · · · · · · · · ·
0.080	Min					
45.2	+/-0.100					
21.8	+/-0.100					
1.4	+/-0.100					
						<u> </u>
		-				
				V		
						No. 10 August 10
l l						
					LL	
Measured by:	T			ł	Date:	
Measured by:						
Audited by:		A			Date:	N/A
Audited by: Prototype Approval:		A			Date:	N/A

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		-	

												QA Closed:	Da	te:	
Work Orde	er:					DISPOSITION				AGAINST D	EΡ	ARTMENT/	PROCESS		
						Rework	]		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab	1	Prod	d. Eng. Coor.		Quality
						Use-as-is	1	Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	No.					Work Order Update	] [		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		nitial	Ad	ction	İ	Sign &			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	cription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling											-				
Operator											İ				
Material											ŀ				
Setup															
Other															
Process											İ				
Supplier															
Training							1								
Unapproved				<u> </u>							$\perp$				
						F	AUL	T CATE	GORY						
Landi	ng (	Gear				General	_			_	_				1
	L	Bending				Bend		Grain			'	Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	L	_ '	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete	L	_	Part Incorre		$\perp$	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear	_	Part Lost/Mi	issing		Wrong Stock Pulled
	Cuffs					Contamination		Mainte	enance	L		Part Moved			
Heat Treat						Countersink		Mislabe	led	L	_	Positioned V	-		1
Inspection Strip in Tube						Cut Too Short		Misread	t			Power Loss/	Surge		Other
Ripples in Bend						Drill Holes		Offset			_				
Torque Waves in Extrusion Dr						Drawing		Out of (	Calibration		_		***************************************		
1 1 1						Finish	Out of Sequence			-					
Wave/Twist in Tube						Folio		Outside	Dimensions						

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98045 03-5

**D3875-1 FLOOR PROTECTOR (206B)** 

NOTES:
1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
7) WEIGHT: 4.0 Ibs.
8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

D

С

В

Α NEW ISSUE 09.01.29 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3875 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE FLOOR PROTECTOR (206B)

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THE DOCUMENT SHOWTH AND CONTROVEN AND IS SERVED ON THE OFFICE CONTROL

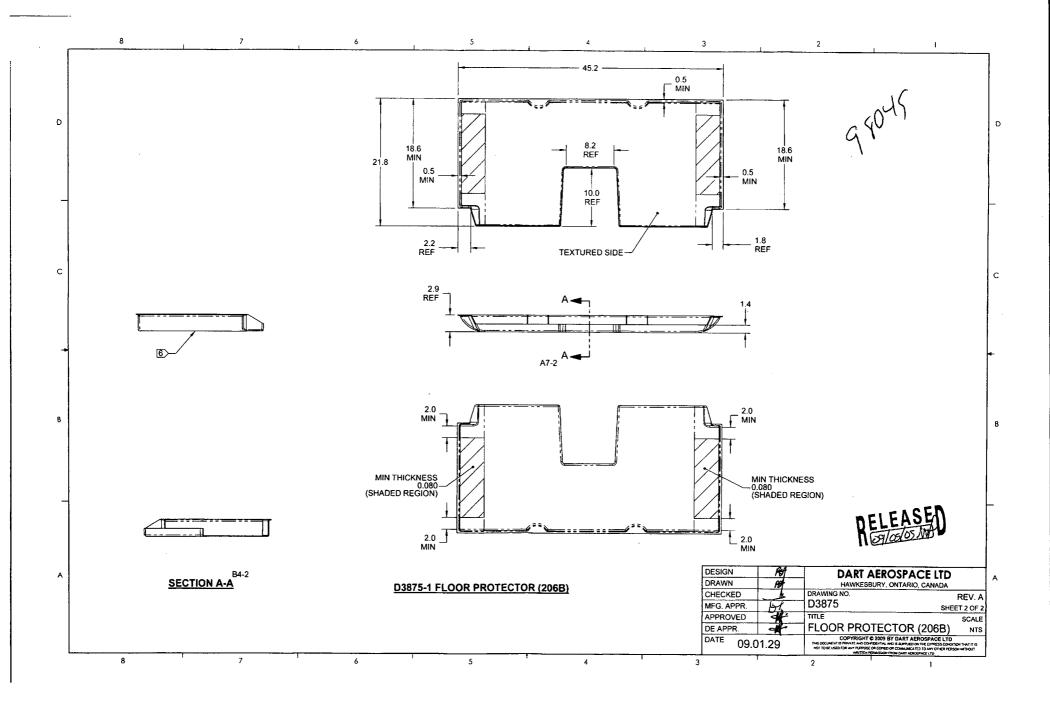
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WHITTEN APPRODUCE OF THE PRODUCE OF THE PROD DE APPR NTS DATE 09.01.29

												DQA:	Date:			
NCR:	Yes	/ No					WORK ORDER NON-	COI	NFORM	/IANCE / UP	DATE					
										<u></u>		QA Closed:	Date	: 		
Vork Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part	,						Rework Scrap			Skid-tube Crosstube Machining Small Fab		Water Jet Prod. Eng. Coor.		Engineering Quality Other		
NCR	No.						Use-as-is The Work Order Update			Thermoforming Finishing Large Fab Composite			Rec/Store/Packaging Supplier			
Root		Descr			crip	iption of work order update		nitial	Action		Sign &					
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining																
		· · · · · · · · · · · · · · · · · ·					F	AUL	T CATE	GORY						
Land	ing (	7			r		General	_	1		<b>r</b>	<b>–</b>				
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped.					Bend BOM/Route Broken/Damaged Burrs		Inspect	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
		Cuffs					Contamination	Maintenance			Part Moved					
		Heat Trea	at		Ī		Countersink	Mislabeled			Positioned Wrong					
		Inspection Strip in Tube					Cut Too Short		Misread	Misread			Power Loss/Surge Other			
		Ripples in Bend					Drill Holes		Offset	Offset						
		Torque Waves in Extrusion					Drawing		Out of Calibration							
		Turning S	equence	!			Finish		Out of Sequence							

Outside Dimensions

Wave/Twist in Tube



											DQA:	Date:			
NCR: Y	es /	No				WORK ORDER NON-O	100	VFORM	/ANCE / UP	DATE	•				
											QA Closed:	Date:			
Work Orde	~r·					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WOIK OIGE	=1				<del></del>	Rework	1	Skid-tube Crosstube				Water Jet	Engineering		
Part N	NO.					Scrap	1 ]	Machining Small Fab			Prod. Eng. Coor.		Quality		
						1 ' <del>                                    </del>			noforming	Finishing		re/Packaging	Other		
NCR N	No.					Work Order Update Large Fab				Composite		Supplier			
Root					l	ption of work order update	1	Initial		ction	Sign &				
Cause		Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data	Ш														
Equip/Tooling	Ш														
Operator									-						
Material	Ш														
Setup							•								
Other															
Process															
Supplier							İ								
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Landi	ng Ge	ar			_	General		,		<del></del>	7.	,	1		
	Ш <sup>в</sup>	ending				Bend		Grain			Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S					BOM/Route	L	Hardwa		<u></u>	Over/Under	<u> </u>	Temperature/Cure		
		racks				Broken/Damaged	L	4 `	ion Incomplete		Part Incorre	<del> </del>	Weld		
		rushed/0	Crimped.			Burrs		-	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs					Contamination Maintenance					Part Moved				
	Heat Treat					Countersink Mislabeled				<u></u>	Positioned \	Wrong	7		
	]ir	spection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	'Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish